

Work Order ID 128355

128355

ASAP

Page 1

Item ID: D4666-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Armrest Assembly
 Start Date: 1/16/15 Start Qty: 8.00 *g* Cust Item ID:
 Required Date: 1/23/15 Req'd Qty: 8.00 *g* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1501-16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4666	A								

100 0.00

100

Large Fab

Large Fab

Large Fab

Memo

1- Cut tube at 38.00"

2- Bend tube as per dwg

3- Cut ends of tube to righth dimension as per dwg

4- Drill tube as per Dwg

6- Deburr

6 A 151-19

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Quality Control

Memo

0.00

Q2

DAS
38
9-89

JAN 19 2015

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January-16-15 12:53:48 PM

Item ID: D4666-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Armrest Assembly
 Start Date: 1/16/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/23/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 128564.</i> Memo START TIME: <i>1:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>1:50</i>	0.00 0.00				<i>8</i>	<i>15-1-21.</i>	<i>238</i>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(8)</i>		<i>38</i> <i>9-89</i>	<i>JAN 22 2015</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST223D</i> Memo	0.00 0.00				<i>8x</i>	<i>JAN 22 2015</i>	<i>DAS</i> <i>26</i> <i>9-89</i>	

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Item ID: D4666-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Armrest Assembly
Start Date: 1/16/15 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/23/15 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

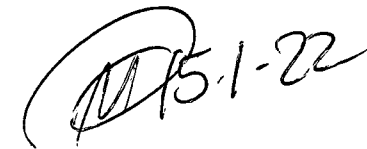
QC

Memo

0.00

Quality Control

MLS 15-01-23



Picklist Print

January-16-15 12:53:48 PM

Page 1

Work Order ID: 128355

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Parent Item: D4666-041

D4666-041

Parent Item Name: Armrest Assembly

Start Date: 1/16/15

Required Date: 1/23/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3017-11		Manufactured	No			124	Each	34.0000	2	16			

D3017-11

Cap

**

Q 1/5/20

Location

Loc Qty

Loc Code

WA001

34

116790

34

M4130NT0.750W.049

Purchased

No

100

f

103.2160

3.17

27

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

Q 1/5/19

Location

Loc Qty

Loc Code

MAT033

103.216

m122425

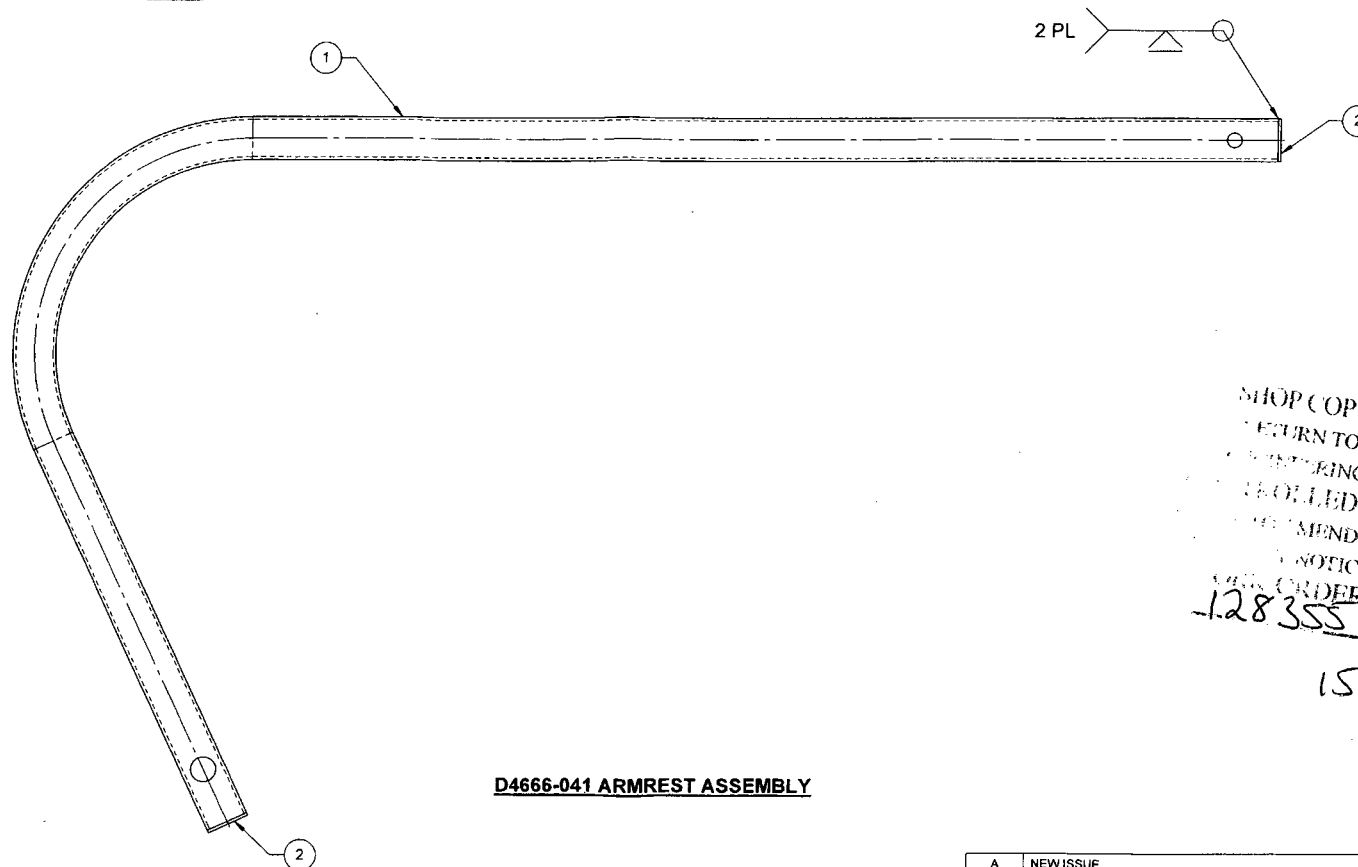
22.5

m130619

80.716

~~23.625~~ 34.625

ITEM	QTY	P/N	DESCRIPTION
	X	D4666-041	ARMREST ASSEMBLY
1	1	D4666-1	ARMREST
2	2	D3017-11	END CAP



D4666-041 ARMREST ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4666-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.01 lbs

RELEASED
2012-07-09
4 PER DEN 12-646

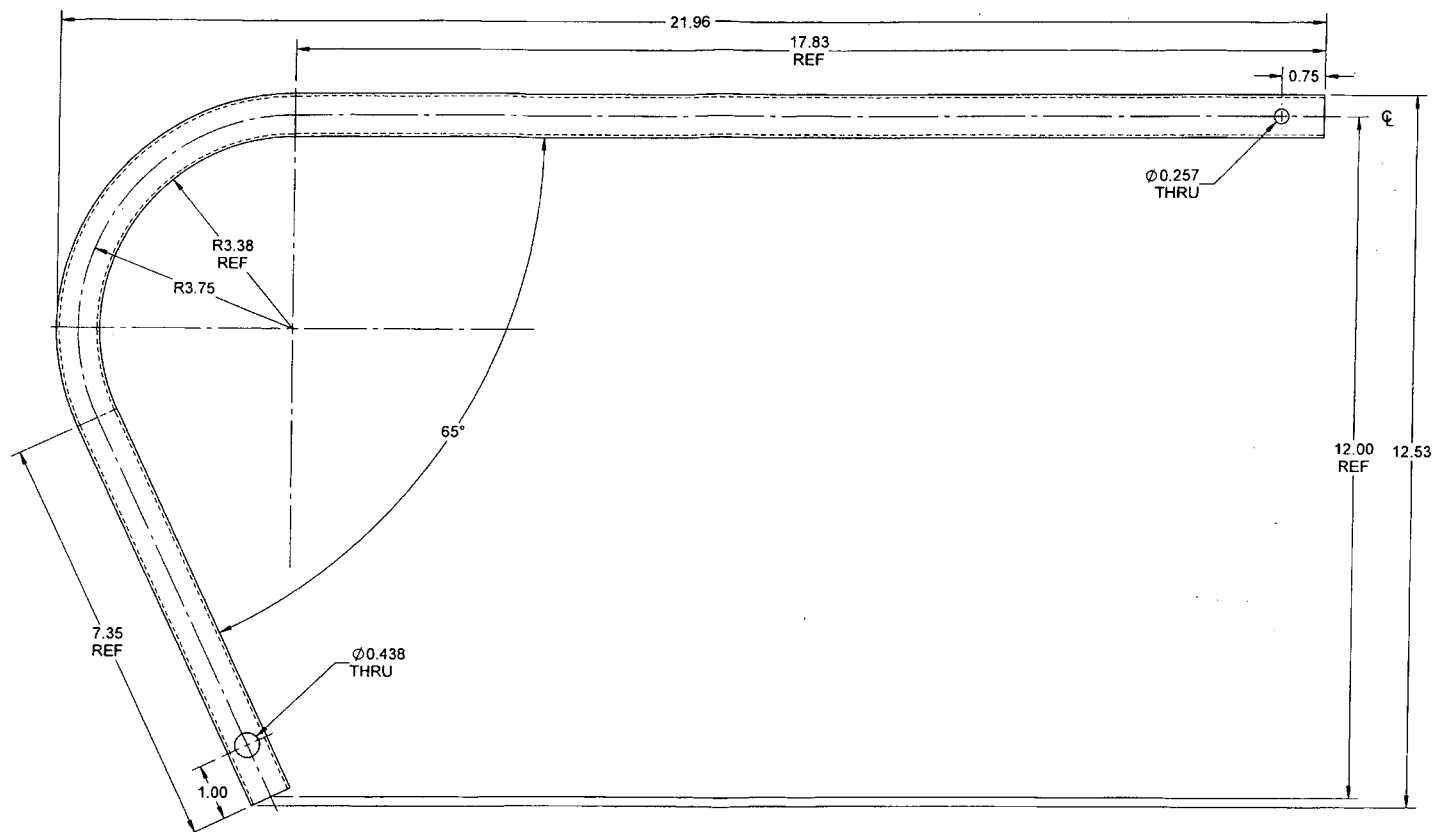
SHOP COPY
RETURN TO
DRAWING
CONTROLLED COPY
NO AMENDMENT
NOTICE
ORDER
128355 HCS
150116

A	NEW ISSUE	AJS	12.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	SP		
MFG. APPR.	IS		
APPROVED	SP		
DE APPR.	SP		
DATE	12.06.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D4666 SHEET 1 OF 2
TITLE SCALE
ARMREST ASSEMBLY NTS

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D4666-1 ARMREST

NOTES:

- 1) MATERIAL: AISI 4130N SEAMLESS STEEL TUBING, $\phi 0.750 \times 0.049$ WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W.049
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) FLAT LENGTH 32.75 ESTIMATED

RELEASED
2012-07-09

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4666	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMREST ASSEMBLY	NTS
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